

Date: Wednesday, 3/8/2006 10:37:45 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26106
 Estimate Number : 12221
 P.O. Number :
 This Issue : 3/8/2006 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : PURCHASED PARTS
 Previous Run :
 Written By :
 Checked & Approved By : *06.03.08*
 Comment : est rev. A 06.02.06 new issue EC

Drawing Name : SHROUD ASSEMBLY
 Part Number : D34671
 Drawing Number : D3467 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 3/31/2006

Qty: *29* Um: Each

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|
|---------|-----------------------|--------------|

| | | |
|-----|-----------------|------------------|
| 1.0 | OUTSIDE SERVICE | OUTSIDE SERVICES |
|-----|-----------------|------------------|



Comment: Sub-Contracting Issue P/O: *00000768*
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3467 flat pattern D3467-1F
 Material release note required

06/03/09

| | | |
|-----|---------|--------------------------|
| 2.0 | D34671F | COVER PLATE FLAT PATTERN |
|-----|---------|--------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 DOUBLER FLAT PATTERN

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

02-06-21 (20)

| | | |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

02-06-22

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr

2-Form as per dwg D3467

SB 06/03/24

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | Hole pattern Incorrect | ASB | Prototype check | VB 06.03.07 | VB 06.03.07 | VB 06.03.07 | VB 06.03.07 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:37:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26106

Part Number: D34671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

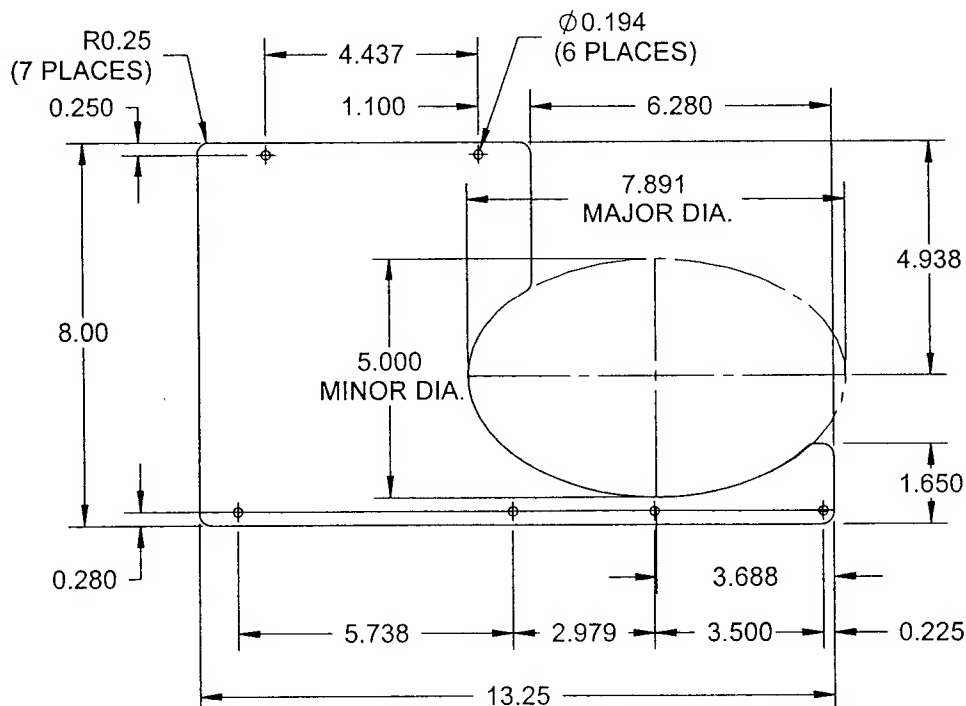
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

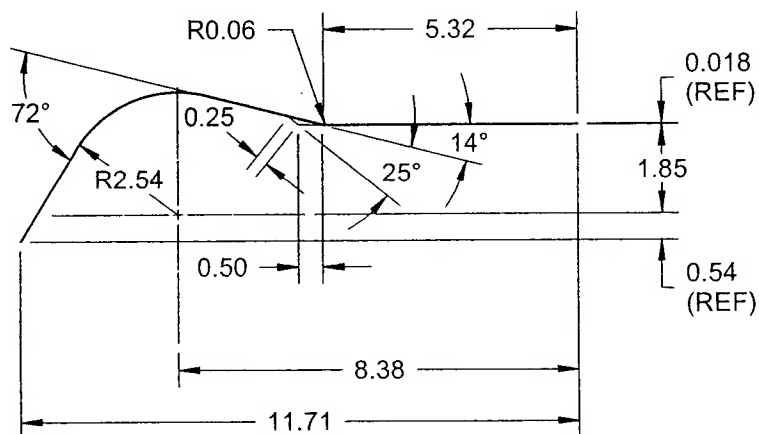
NOTE: Date & initial all entries

PRELIMINARY ISSUE

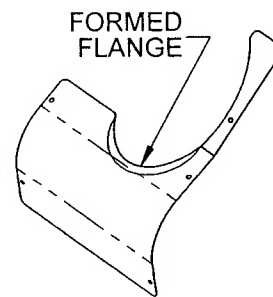
| | | | |
|-------------------------|----------|--|-------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3467 | REV. A SHEET 6 OF 15 |
| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |



D3467-1F COVER PLATE FLAT PATTERN



D3467-1 LH COVER PLATE
D3467-2 RH COVER PLATE (OPPOSITE)



D3467-1 LH COVER PLATE ISOMETRIC VIEW
D3467-2 RH COVER PLATE (OPPOSITE)
SCALE 1:8

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

3/17/06
ATTN: JETE

604-946-4153

| | | | | | | | | | | | | |
|--|-------|---|-------|---|------------------------|----------|-----------|-------------------|-------------------|-------------------|-------------------|--|
| AK Steel | | AK Steel Corporation | | Page 1 | | | | | | | | |
| Metallurgical Test Report | | Coastcon Works | | Coastcon, OH 43812 | | | | | | | | |
| INTEGRIS METALS P.O. BOX 340 MINNEAPOLIS, MN 5540 | | INTEGRIS METALS 300 B STREET ALBURN, WA 98001 | | Lead No. 710672 SER No. 710672 | | | | | | | | |
| C U T T E R S | | S H I P T O | | MILL ORDER NO. 77106-0191 PROCESSOR ORDER NO. 477105-01 BUYER'S ORDER NO. 427116-01 | | | | | | | | |
| PART NO. 71051071 EXHAUSTIVES - PRODUCT - METRIC UNITS 210 NOM 40000 X COIL | | PART NO. 71051071 EXHAUSTIVES - PRODUCT - METRIC UNITS 210 NOM 40000 X COIL | | | | | | | | | | |
| SK071313 1 71051071 050019-01 4.02 KG. | | SK071314 1 71051071 050019-01 4.03 KG. | | SK071315 1 71051071 050019-01 4.04 KG. | | | | | | | | |
| SK071316 1 71051071 050019-01 4.05 KG. | | SK071317 1 71051071 050019-01 4.06 KG. | | SK071318 1 71051071 050019-01 4.07 KG. | | | | | | | | |
| TOTAL SKIDS 4 TOTAL NET WEIGHT 16.05 KG. | | TOTAL SKIDS 4 TOTAL NET WEIGHT 16.05 KG. | | | | | | | | | | |
| L-Label Analysis of Heat P-Product Analysis of Parent Coil CHEMICAL ANALYSIS | | | | | | | | | | | | |
| ID | C | MN | P | S | SI | CR | NI | MO | N | CU | CO | |
| L 71051071 | 0.049 | 1.39 | 0.027 | 0.001 | 0.35 | 0.18 | 0.05 | 0.35 | 0.04 | 0.30 | 0.12 | |
| SHIPPING DATE: 03/15/2005 REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS ON ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL. | | | | | | | | | | | | |
| PRODUCT DESCRIPTION CR SHV STEEL 304 STAINLESS STEEL FINISH SLIT EDGE * AMS 2612 * ALL TEST SPEC HAVE BEEN MET UNLESS SPECIFIED TO OR NOTED OTHERWISE * A SYN A 240 -04 EX PARA 3.1.3 COILS WILL BE DETERMINED BY ASTM E 8 * AFTER A 400 -01 EX PARA 19.1.1 ELONG WILL BE DETERMINED BY ASTM H & S EX PARA 26.1.1.3 COIL WILL BE TAPPED ON OUTSIDE ONLY * AFTER A 666 -03 * IN-011 Rev 0, * IN-011 0 * BUYER PART# 74251497 * ASME SA-240 SECTION II PART B (2001 ED, 2002 ADDENDA) RE PARA 3.1.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 * EX-10234 3.1.3 | | | | | | | | | | | | |
| PARENT COIL ID | FORM | DIR | COND | 2 INCH MEASURED | TENSILE STRENGTH (ksi) | YS (ksi) | ELONG (%) | ROCKWELL HARDNESS | ROCKWELL HARDNESS | ROCKWELL HARDNESS | ROCKWELL HARDNESS | |
| 454499-02 | 1 | T | 1 | 1.0 | 145.2 | 117.1 | 17.1 | 72 | 72 | 72 | 72 | |

CONTINUED ON NEXT PAGE

Ryerson

3/17/2006 1:57

PAGE 002/002

Fax Server

MAY-17-2006 16:05

FROM-INTEGRIS

253-288-8833

T-726 P.008/015 F-537



AK Steel Corporation
Metallurgical Test Report
Construction Works
Coshocton, OH 43812

Page 2

Lot# No. 7410572
 BRN No. 7410672

WILL ORDER NO. PROCESSOR ORDER NO. BUYER'S ORDER NO.
 47248-091 427136-01 427136-01

INTEGRIS METALS
 PO BOX 390
 MINNEAPOLIS, MN 55440

INTEGRIS METALS
 305 "B" STREET
 AUBURN, WA 98001

PART NO. 7425107
 ENGLISH UNITS - PRODUCT - METRIC UNITS
 305 INCH 48608 X COIL

| ITEM NO. | DESCRIPTION | QTY | UNIT |
|----------|-------------|-----|------|
| 0 | | | |

| PARENT COIL | POS | DIR | COND | ASTM | BEND | TEST | ROCKWELL | ROCKWELL |
|-------------|-------|-----------|-------|-----------|----------|----------|----------|----------|
| ID | (W/T) | (L, T, D) | | A 36 | 180 | | | |
| 056919-02 | T | | AS.TM | PASS | 17 | | | |
| PARENT COIL | POS | DIR | COND | 3/16 INCH | STRENGTH | 25 OFFER | HARDNESS | HARDNESS |
| ID | (W/T) | (L, T, D) | | MEASURED | (KSI) | (KSI) | Tail | Front |
| 056919-02 | F | T | AS.TM | 71.0 | 92.8 | 33.1 | B 72 | B 74 |
| PARENT COIL | POS | DIR | COND | BEND | | | | |
| ID | (W/T) | (L, T, D) | | 17 | | | | |
| 056919-02 | F | | AS.TM | PASS | | | | |

THIS CERTIFIED ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT
 AS COMPARED WITH THE RECORDS OF THIS CORPORATION.

ALL TESTS WERE DONE IN ACCORDANCE WITH ASTM SPECIFICATIONS UNLESS OTHERWISE NOTED

AS SHOWN ON PAPER

INTEGRIS METALS

THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CUSTOMER OF INTEGRIS METALS FROM AK
 Steel Corporation. TO AVOID THE POSSIBILITY OF MISUSE OR DELIVERY OF THE REPORT TO A
 THIRD PARTY, IT MUST BE REPRODUCED BY AND UNDER THE NAME OF SUCH CUSTOMER.

SIGNED

Steve Ryerson
 AMERICAN STEEL

DATE 5/17/2006 TIME 10:41 AM

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K8
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 415824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 FRM, AMS5513H X MK&FIN, MIL5059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aE; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

| | | UOM | L | O | UOM | L | O |
|------------------------------|-------|-----|---|--------|-----|---|---|
| Yield Strength - 0.2% Offset | 40 | KSI | F | TRANSV | | | |
| Tensile Strength (UTS) | 93.3 | KSI | F | TRANSV | | | |
| Rockwell B | 85 | | F | TRANSV | | | |
| Pct Uniform Elong 2 In/50mm | 57.01 | PCT | F | TRANSV | | | |
| Rockwell A | 85 | | T | TRANSV | | | |

Chemical Composition

| | | | |
|-------------------|-------|------------------|--------|
| C Carbon-Pct | .059 | CR Chromium-Pct | 18.360 |
| CU Copper-Pct | .342 | MN Manganese-Pct | 1.643 |
| MO Molybdenum-Pct | .285 | N Nitrogen-Pct | .037 |
| NI Nickel-Pct | 8.150 | P Phosphorus-Pct | .029 |
| SI Silicon-Pct | .289 | | |

Comments

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GUKLPH , ONN K123
Control #: 90C60214
Part #: 74271441
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDA LASH

TO 110880

S/P 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.

